

# CLAIMS

1. Laser welding method for the assembly of metal parts arranged in the shape of a T, the stem of the T being formed of a stem plate (10, 30) with parallel surfaces, the assembly only being accessible  
5 from the head side of the T, through an external surface, the method comprising the following phases:

- T assembly of parts adjacent to each other,
- laser welding of the assembly through the outer surface of the T head, by two welds made at the  
10 same time and parallel to each other and perpendicular to the top surface of the head of the T, such that each of the two welding axes (21) is tangent to one of the surfaces of the plate (10, 30) forming the stem of the T.

15 2. Laser welding method according to claim 1, characterised in that the two welds are made simultaneously with a bifocal welding head (20).

3. Laser welding method according to claim 1, characterised in that the stem plate (10) is provided  
20 with tabs (11) with a determined length and thickness, and the assembly includes a second part called the head part (15) forming the head of the T and provided with slots (16) with length and thickness corresponding to the dimensions of the tabs (11).

25 4. Laser welding method according to claim 3, characterised in that the height of the tabs (11) is slightly more than the thickness of the head part (15).

5. Laser welding method according to claim 1, characterised in that the head of the T is formed of  
30 two plates (35D, 35G) installed perpendicular to the

plate of the T stem (30) and with their edge in contact with the stem plate.